

Work Order ID 108616

108616

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October-24-13 11:47:05 AM

D4006-041

Item ID: D4006-041

Accept

N900040100

Setup Start

NS1

Revision ID:

B108616

Item Name: Tank Top Support Assembly

Stop

NS2

Start Date: 10/24/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/30/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4006

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Gloss Grey (4.3.5.15) per QSI 005.4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

Start Time:

Oven Temperature:

Finish Time:

spray paint

primer 126 558

Paint m 127810

DAS
36
9-89

DAS

27

9-89

4/1/17

4

(4)

C.R. 14/02/18

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108616

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Item ID: D4006-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Top Support Assembly

Start Date: 10/24/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish 14 Memo	0.00 0.00 11/2/19				4			
140 *140* HandFinish Hand Finishing	Memo 1- Apply glue and install Foam as per dwg 3M 1300L Batch: 127443 2- Install anchor nuts as per dwg	0.00 0.00				(4)			FF 14-02-19
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 11/2/19				4			

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October-24-13 11:47:05 AM

Item ID: D4006-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tank Top Support Assembly

Start Date: 10/24/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo 2x ship	0.00				4x	DAS 28 9-89	14-02-19	
Packaging	2x 5T242								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14-02-19

14-02-19

Picklist Print

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Page 1

Work Order ID: 108616

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 10/24/13

Required Date: 10/30/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD
562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM
IPP Rev:B 10.05.03 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 Angle		Manufactured	No			100	Each	7.0000	1	4		14/01/17	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		7							
				100362		7				4			
D4006-3 Channel		Manufactured	No			100	Each	0.0000	2	8		14/01/17	DAS 36 9-89
D4006-5 Foam		Manufactured	No	B 107393		140	Each	0.0000	1	4		14/01/17	FF
MS20426AD3-4 RIVET		Purchased	No	B 111349		140	Each	10,646.000	4	16		14/01/17	FF
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST334		35							
				123164		35							
				ST505		2491							
				104374		12							
				123021		12							
				124814		2467							
				ST509		8120							
				124586		120							
				125578		8000				16			
MS20470AD4-5 RIVET, UNIVERSAL HEAD		Purchased	No			100	Each	2,689.0000	8	32		14/01/17	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST336		2689							
				125654		9							
				m126926		2680				32			

Picklist Print

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Work Order ID: 108616

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 10/24/13

Required Date: 10/30/13

Start Qty: 4.00

Required Qty: 4.00

MS21059L4

Purchased

No

140

Each

76.0000

2

8

Nutplate

Location

Loc Qty

Loc Code

GA

55

125535

55

ST316

21

122441

6

123900

15

FF 14-02-19

2

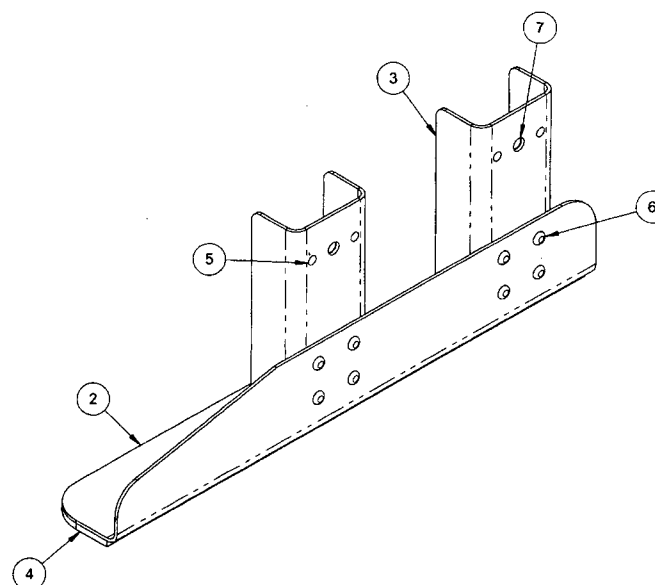
6

October-24-13 11:47:04 AM

Shop Packet Print

Page 2

ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3(-4)	RIVET	
6	8	MS20470AD4(-5)	RIVET	
7	2	MS21059-4	ANCHOR NUT	



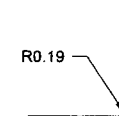
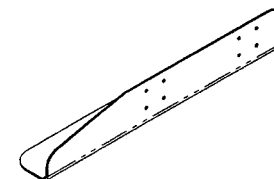
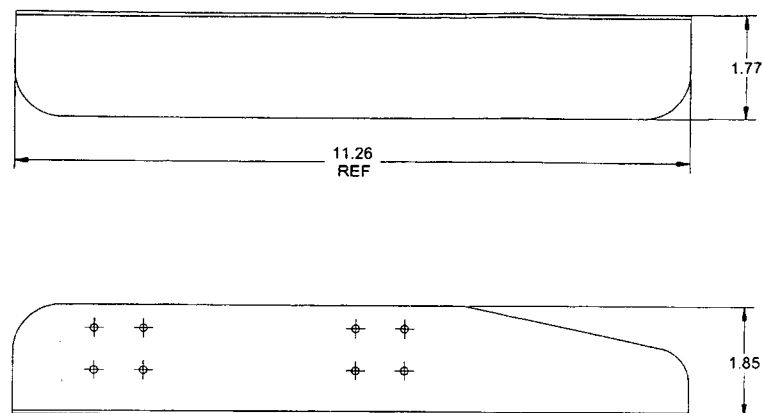
D4006-041 TANK TOP SUPPORT ASSEMBLY

9/10, 108616

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.48 lbs

B	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A7-1.	DC	12.02.28
A	NEW ISSUE	BY	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>	DRAWING NO.	REV. B
CHECKED	<i>BC</i>	D4006	SHEET 1 OF 6
MFG. APPR.	<i>BC</i>	TITLE	SCALE
APPROVED	<i>BC</i>	UPPER RESTRAINT	NTS
DE APPR.	<i>BC</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.02.28		

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



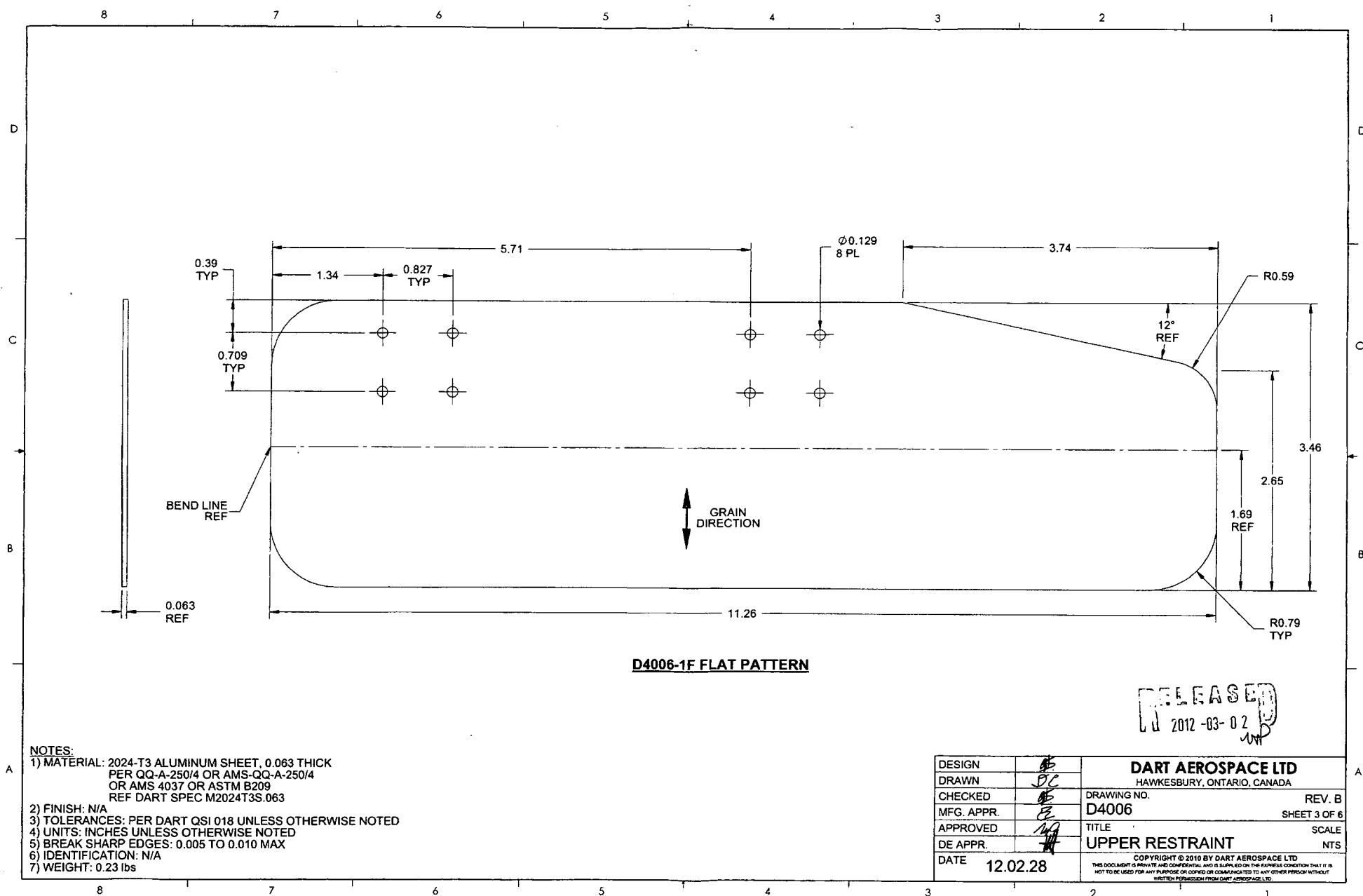
D4006-1 ANGLE

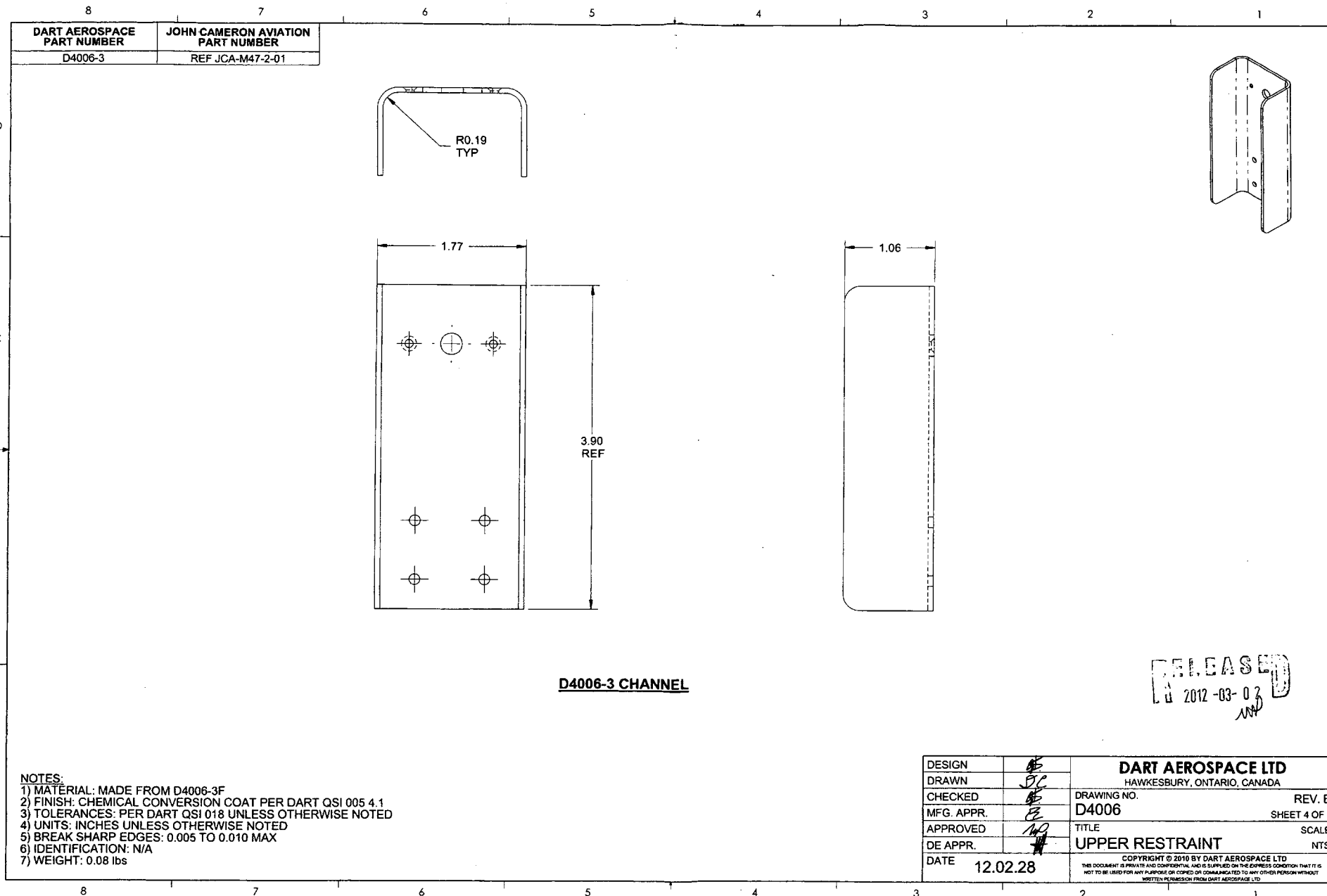
RELEASED
2012-03-02
M

NOTES:

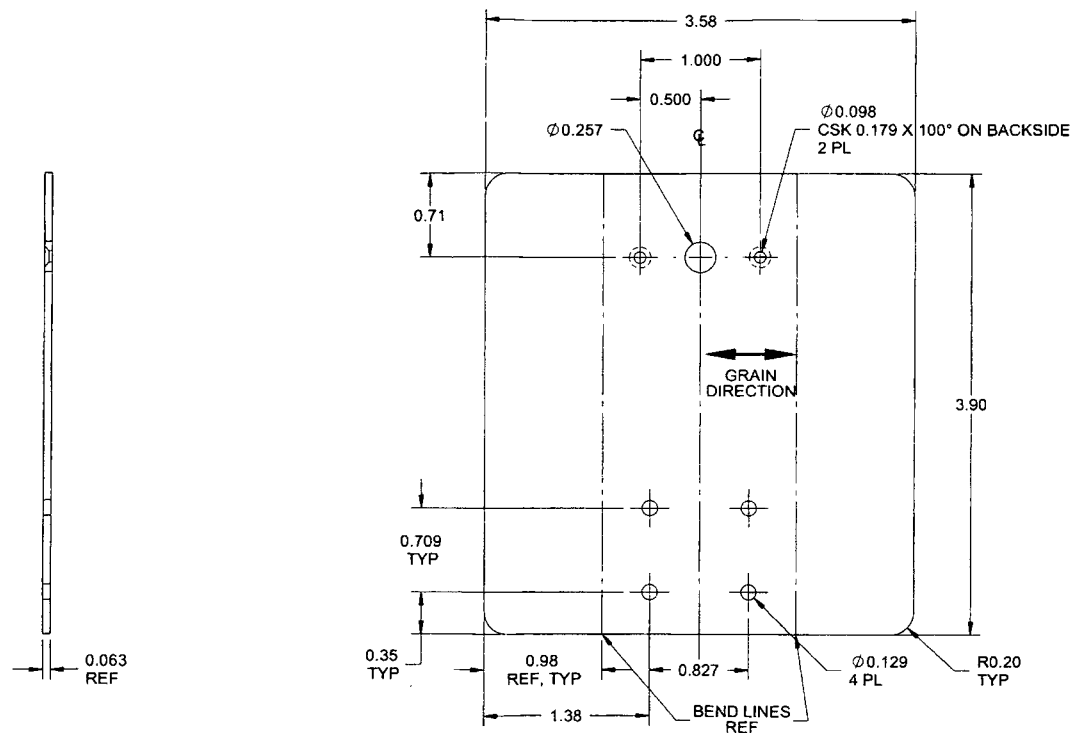
- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>BC</i>	D4006	SHEET 2 OF 6
APPROVED	<i>BC</i>	TITLE	SCALE
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RELEASED
2012-03-03
WJ



D4006-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	E	D4006	SHEET 5 OF 6
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	UPPER RESTRAINT	NTS
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2012-03-02

DART AEROSPACE
PART NUMBER

D4006-5

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01

R0.79
TYP

11.26

1.52

0.13
REF

D4006-5 FOAM

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4006	SHEET 6 OF 6
APPROVED	<i>MA</i>	TITLE	SCALE
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